

**Work Order ID 74173**

Monday, September 26, 2011 2:46:38 PM

Page 1



Item ID: D205-634-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D205-634

G

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-141 CHG001

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

0.00

Memo

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

*see wlb 74173*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

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**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**

**THE UNIVERSITY OF CHICAGO**



**Customer:**

**Reference:**

Run Start

\_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Abstract**

## Operation Description

## Set Up/ Run Hours

## Tool ID

Tool #

## Plan Code

**Accept**  
**Qty**

## Reject Qty

## Reject Number

**Insp.  
Stamp**

120

0.00

[illegible]

0.00

## Skidtubes

## Skidtubes

## Memo

1- Deburr ends and remove bending marks

2- Prepare tube for welding as per QSI 004

0.00

130

**THE UNIVERSITY OF CHICAGO**

0.00

QC

## Quality Control

## Memo

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Weld spacers as per dwg D2580

4- \*\*\* N/A\*\*\* Insert D4202-1 spacer, swage as per QSI002 and trim/ grind  
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2  
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

QC10- Inspect visual per QSI004- ground welds 0.00

150



QC

Quality Control

Memo

0.00

Drill holes for Run on wear plates as per dwg D2580 pg 7. DP 11-11-24

5000  
auto  
76417  
U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Process Plan:

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Date:




Stop

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Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
170  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00  0.00							
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00  0.00							

See also 74117

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*1 BL 11-11-30.*

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearplates as per Dwg. D2580.

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive  
A/R ☐ ☐ ☐ Sikaflex-291 ☐ *119443*  
Sikaflex expire date: *12-1.*

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: *118988.*

*1 BL 11-11-30.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

11/12/2011 01-01

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-141

Location:

PPP Rev:

PPD 74163

11/12/2011

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 11-12-01

11/12/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 1

Monday, September 26, 2011 2:46:35 PM

Work Order ID: 74173

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube



Start Date: 9/26/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 11.09.14 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-45A Bolt		Purchased	No				Each	200.0000		8			
-----------------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--

Location

Loc Qty

Loc Code

ST349

200

118926

200

Each

122.0000

8

16

BR 11-12-1

BR 11-12-1

\*

D2570

Bushing

Manufactured No

Location

Loc Qty

Loc Code

ST349

122

66933

1

67759

6

72122

1

72960

72

73636

42

Each

443.0000

16

20

D4202-1

Spacer

Manufactured No

Location

Loc Qty

Loc Code

LG002

443

66929

106

67129

196

67308

1

67430

140

see w/o 76417

D205-634-CH1 # 76417

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74173



Parent Item: D205-634-141



Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

D4406-041 Manufactured No

Each 1.0000

1



Fwd Wearplate Assembly



BR 11-12-1.

Location

Loc Qty

Loc Code

ST 7417.  
71909

1

1

0.

D4406-043 Manufactured No

Each 1.0000

1



Aft Wearplate Assembly



BR 11-12-1.

Location

Loc Qty

Loc Code

ST \*74148.  
72640

1

1

1

MS21042-4 Purchased No

Each 252.0000

8



USE MS21042L4



BR 11-12-1.

Location

Loc Qty

Loc Code

\*T299 119017.  
100743  
5389  
5461  
6844  
7690  
8182  
9229

252

9

78

3

19

24

115

4

8.

D2580-1 Manufactured No

Each 1.0000

1



205 Skidtube bent detail



Location

Loc Qty

Loc Code

LG  
\*76417 2965

1

1

*Handwritten notes:*  
A see w/o # 76417  
h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3

Manufactured No



Step (maching detail)

Location

Loc Qty

Loc Code

LG

72

66156

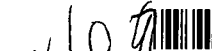
22

70883

50

72.0000

1



76417

D2855

Manufactured No



Cap

Location

Loc Qty

Loc Code

FP007

18

65519

2

65569

16

18.0000

1



BR 11-12-1.

AN3-5A

Purchased No



Bolt

Location

Loc Qty

Loc Code

ST350

886

115371

46

117423 ✓

540

118626

300

886.0000

2



BR 11-12-1.

AN960JD10L

\* NAS1149D0332J ✓ Purchased

No



Washer

Location

Loc Qty

Loc Code

ST350

886

115371

46

117423 ✓

540

118626

300

0.0000

2



2. BR 11-12-1.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No

Each 884.0000 8



O-Ring, 205 Skidtube



BR 11-12-1.

Location

Loc Qty

Loc Code

FP004

198

73490

198

FP-A

686

65518

41

66952 ✓

347

73490

298

8.

D2594-1 Manufactured No

Each 254.0000 8



Plug, 205 Skidtube



BR 11-12-1.

Location

Loc Qty

Loc Code

FP

172

73401

172

FP-A

82

42807

28

67441

7

72127

47

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960J10L)
27			8	MS21042-4	NUT (OR MS21042L4)

# **GENERAL NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs  
D2580-045 = 34.5 lbs  
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED  
2011-08-29  
WD

WLO 24/73

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 1 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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C

B

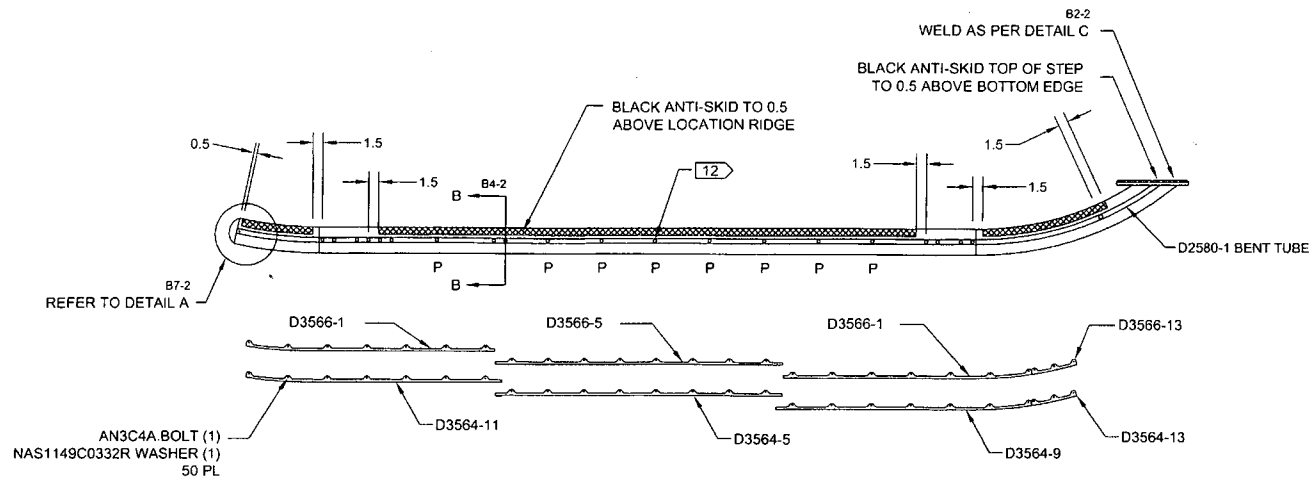
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D

C

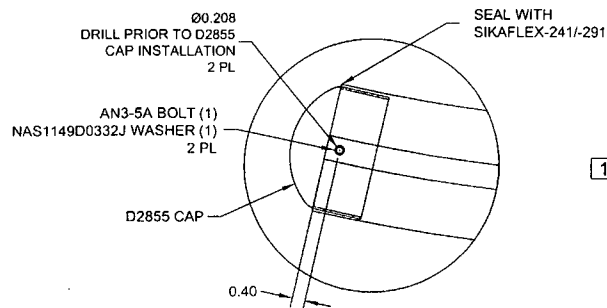
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A

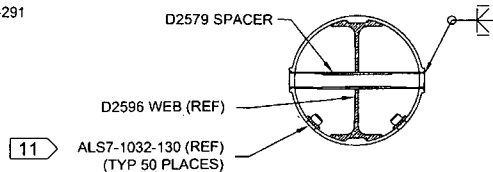


D2580-041 ASSEMBLY DETAIL

DETAIL A  
SCALE 5X

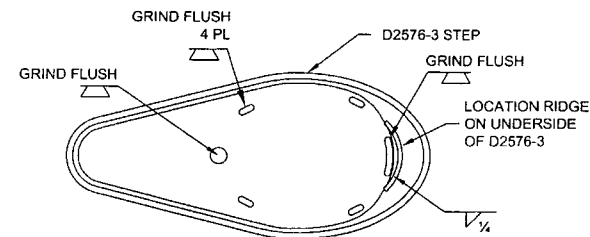


SECTION B-B  
SCALE 5X



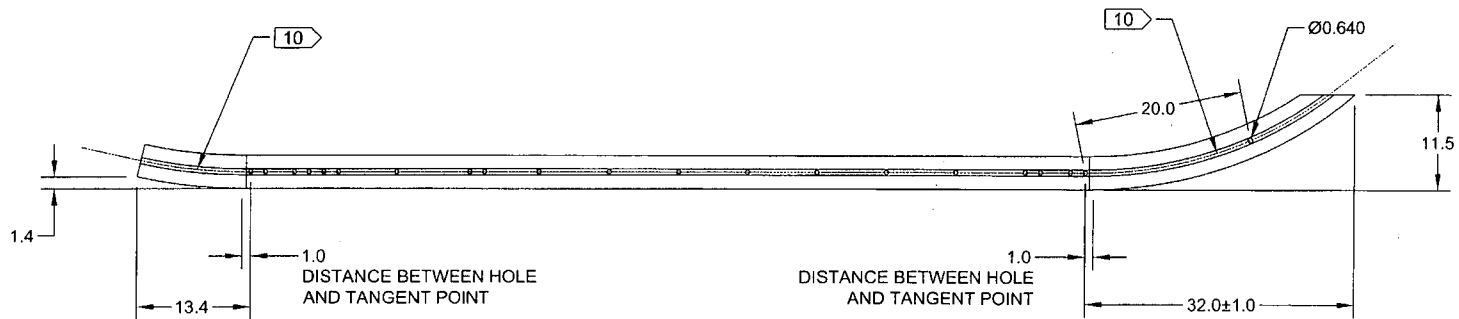
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL C  
SCALE 5X



DESIGN	<del>4</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	<del>10</del>	D2580	SHEET 2 OF 8
APPROVED	<del>10</del>	TITLE	SCALE
DE APPR.	<del>10</del>	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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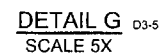
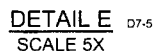
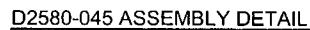
8 7 6 5 4 3 2 1



D2580-1 BENT TUBE  
(MAKE FROM D2580-101 TUBE)

RELEASED  
2011-08-28

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 3 OF 8
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DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	N	D2580	SHEET 4 OF 4
APPROVED	N	TITLE	SCALE
DE APPR.	#	205 SKIDTUBE ASSEMBLY	
DATE	11.06.21	NT	

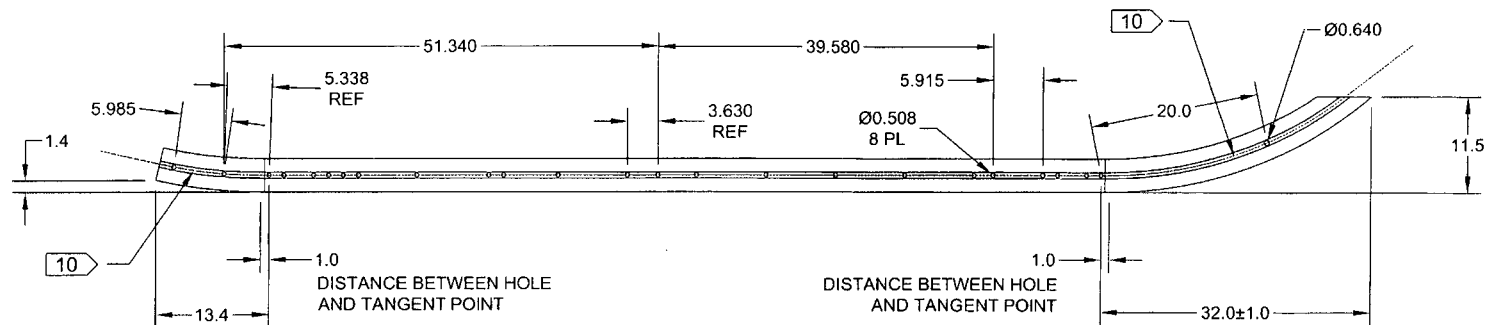
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**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. E
D2580	SHEET 4 OF 8
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	NTS

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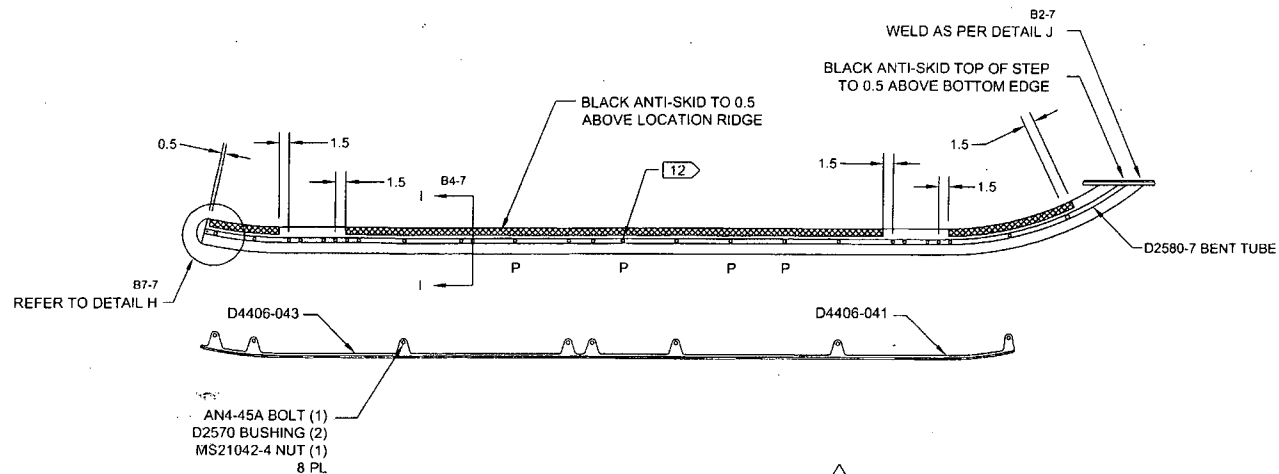




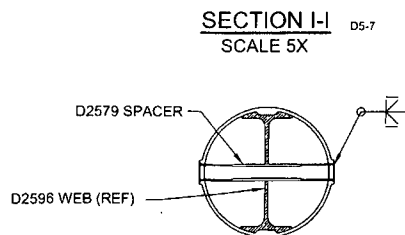
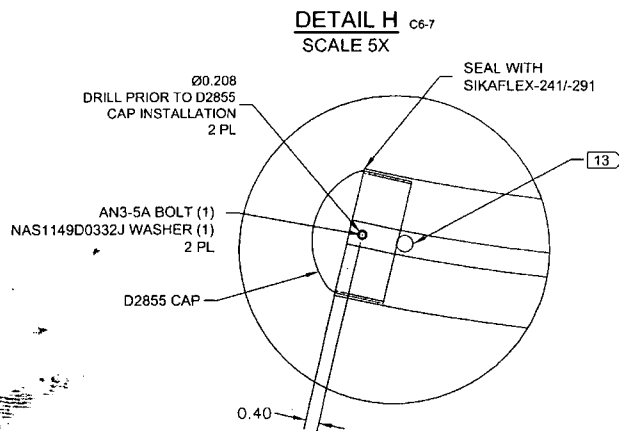
**D2580-5 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

**RELEASED**  
2011-08-29

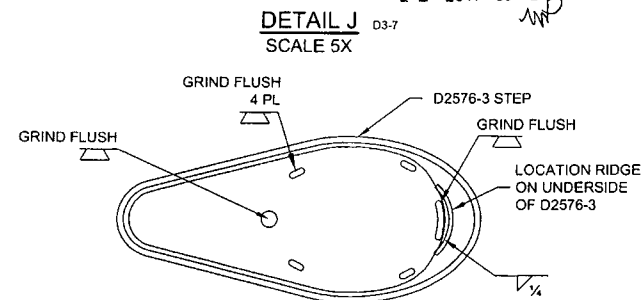
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	140	D2580	SHEET 5 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	205 SKIDTUBE ASSEMBLY	NTS
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D2580-047 ASSEMBLY DETAIL E



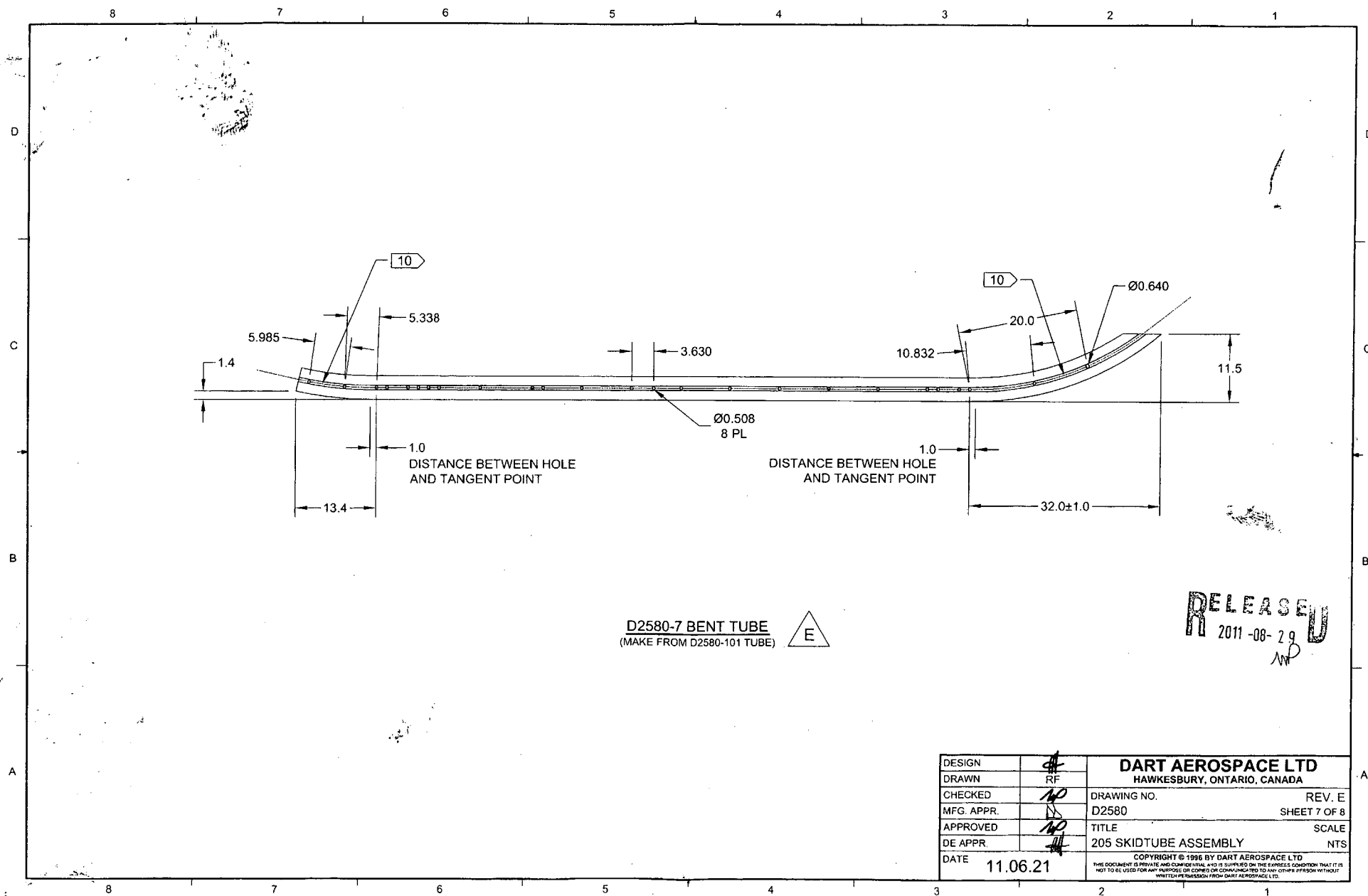
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (25 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

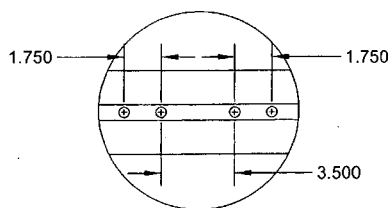
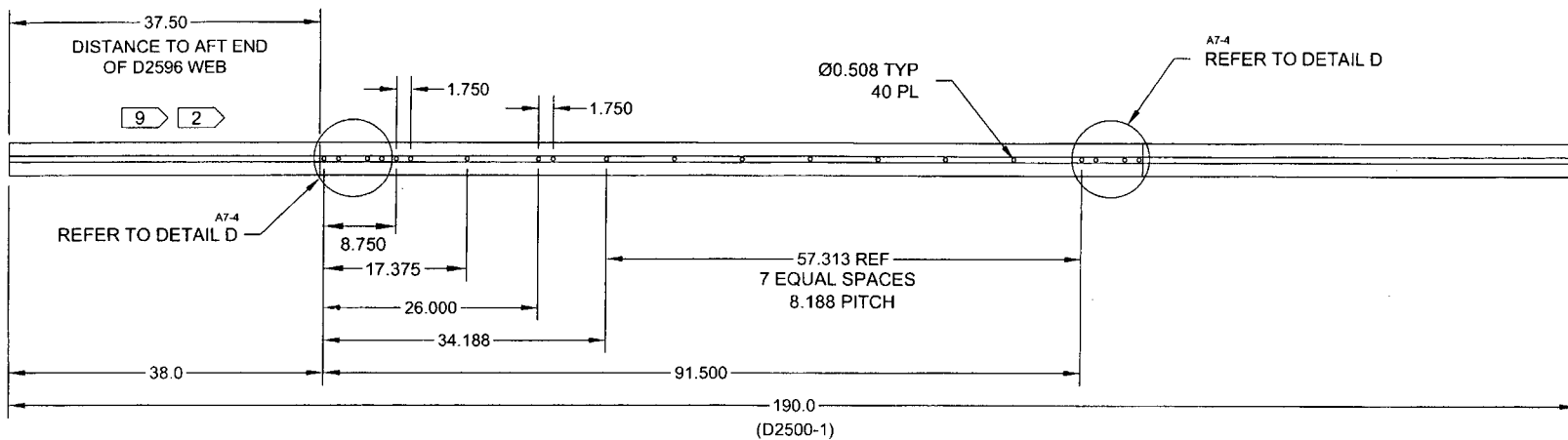


DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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2011-08-29







**DETAIL D** D3-4  
SCALE 5X C7-4

D2580-101 TUBE

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2011-08-29

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CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 8 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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